



## Electrodes for Mild Steels 6013

Arc welding rods for mild steel and medium tensile steels. Medium rutile coated, all positional rods.

**Applications:** for steel plate and strip including structural steels and pipe work, especially under site conditions. Superb finish with self-releasing slag. **N.B.** Suitable for AC (50V minimum open circuit) and DC +/-.



**FOR MILD  
STEEL &  
C-Mn  
STEEL**

### Recommended Amperages

Size (mm)	2.5	3.2	4.0
Min.	70A	95A	130A
Max.	100A	125A	170A

Size (mm)	No. of Rods (per pack)	Weight (per pack)	Order Code KEN-891	Price/Pk TB
2.50 x 300	260	5.0kg	-3010K	1496.00
3.25 x 350	150	5.0kg	-3020K	1496.00
4.00 x 350	100	5.0kg	-3030K	1643.00

## Electrodes for Mild Steels

### E7018 ('Low Hydrogen')

Basic coated, all positional rods.

**Applications:** for steel plate structural steels, pipe work and forgings. Ideal for repairs of casting and machinery, compensate for dilution effect of poor steels. Often used where rutile deposits may be at risk from cracking. **N.B.** Suitable for AC (70V minimum open circuit) and DC+. Optimum root opening operability is obtained using DC-. Conforms with AWS and BS EN standards..



**FOR MILD  
STEEL &  
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### Recommended Amperages

Size (mm)	2.6	3.2	4.0
Min.	70A	95A	130A
Max.	100A	125A	170A

Size (mm)	No. of Rods (per Pk)	Weight (per Pk)	Order Code KEN-891	Price/Pk TB
2.60 x 300	260	5.0kg	-5110K	1388.00
3.20 x 350	150	5.0kg	-5120K	1530.00
4.00 x 450	100	5.0kg	-5130K	1643.00

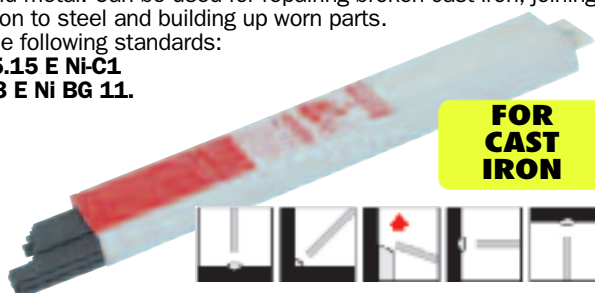
## Electrodes For Cast Iron

### S-NFC

A Graphite coated iron-nickel alloy electrode for high strength jointing of cast iron and cold welding of cast iron, it deposits 95%Ni + 2%Fe weld metal. Can be used for repairing broken cast iron, joining of cast iron to steel and building up worn parts.

Meets the following standards:

**AWS A 5.15 E Ni-C1**  
**Din 8573 E Ni BG 11.**



**FOR  
CAST  
IRON**



Type	Size (mm)	Recommended Amperage	Order Code KEN-891	Price/Pk TB
S-NFC	2.5	70A	-1220K	5356.00
	3.2	100A	-1230K	5202.00
	4.0	145A	-1240K	4893.00

## Electrodes for Stainless Steels

### 316L

A Lime-Titania electrode giving excellent use ability and weldability, it deposits 19.5%Cr - 11.7%Ni - 2.5%Mo weld metal. The Austenite structure gives good crack resisting properties. For welding of extra-low carbon 18%Cr-12Ni-Mo stainless steel.

**FOR  
STAINLESS**



### Recommended Amperages

Size (mm)	1.6	2.0	2.6	3.2	4.0
Min.	20A	25A	50A	80A	120A
Max.	40A	55A	90A	125A	180A

Type	Size (mm)	Number of Rods (Per Pk)	Weight (per Pk)	Order Code KEN-891	Price/Pk TB
316L	1.6 x 300	395	2.50kg	-1100K	4481.00
	2.0 x 300	200	2.50kg	-1110K	4326.00
	2.6 x 300	130	2.50kg	-1120K	3708.00
	3.2 x 350	70	2.50kg	-1130K	3605.00
	4.0 x 350	45	2.50kg	-1140K	3451.00

## S312 Stainless/Dissimilar Electrodes

A Lime-Titania electrode giving excellent use ability and weldability, it deposits 29%Cr + 9%Ni weld metal. The Austenite nature resists cracking and provides a superb buffer effect against outer stress. For bond welding of dissimilar metals such as stainless steel, carbon steel, low alloy steel and welding of stainless clad steel.

**FOR  
STAINLESS**



### \* Sizes available on request

### Recommended Amperages

Size (mm)	1.6*	2.0*	2.6	3.2	4.0
Min.			50A	80A	120A
Max.			90A	125A	180A

Size (mm)	Number of Rods (Per Pk)	Weight (Per Pk)	Order Code KEN-891	Price/Pk TB
2.60 x 300	260	2.50kg	-1030K	3605.00
3.20 x 350	150	2.50kg	-1040K	2833.00
4.00 x 350	100	2.50kg	-1050K	3348.00

## Twist Grip Short Stub Electrode Holders

Reduce fatigue and increase safety. All of the electrode is available for use and the angle allows the hand to remain away from the weld pool. The handle applies torque to the electrode clamp in the head.



Rating (Amps)	Handle Colour	Order Code KEN-885	Price/1 TB
400	Yellow	-6010K	446.00
400	Red	-6110K	465.00
600	Red	-6130K	465.00